

# Work Order ID 95286

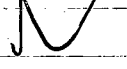
**\*95286\***

Page 1

January-08-13 7:50:47 AM

Item ID: D3827-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Rib Assembly (Inboard)  
 Start Date: 1/08/13 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 1/08/13 Req'd Qty: 2.00 **\*2\*** Customer:

Reference:

Approvals: Process Plan:  Date: Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3827	Rev A

100	0.00
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**\*100\***

Large Fab

Large Fab

Large Fab

Memo

0.00

1- cut D3827-1 rib as per dwg D3827

2- drill holes using DT9435 jig and open to finish size as per dwg D3827

3- c'sink as per dwg

4- remove identification markings

5- deburr

6- weld bushing in rib as per dwg D3827

A/R S.S. Rod Batch: M122130

7- grind weld flush

8- deburr if necessary

*Pl 13.1.8*

*(2)*

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Page 2

January-08-13 7:50:47 AM

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Approvals: Process Plan: Date: Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00  0.00							
			DAS 16 9-89	13/01/08					
140 <b>*140*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00							
			DAS 16 9-89	13/01/08					
150 <b>*150*</b> Packaging Packaging	Identify as per dwg & Stock Location: <u>WA005</u>  Memo	0.00  0.00							
				PC 13-1-11					
						2			

**Work Order ID 95286****\*95286\***

Page 3

January-08-13 7:50:47 AM

Item ID: D3827-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
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**Reference:**

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

13/1/11

PL 13-01-8

# Picklist Print

January-08-13 7:50:47 AM

Page 1

Work Order ID: 95286

Parent Item: D3827-041

Parent Item Name: Rib Assembly (Inboard)

Start Date: 1/08/13

Required Date: 1/08/13

Start Qty: 2.00

Required Qty: 2.00

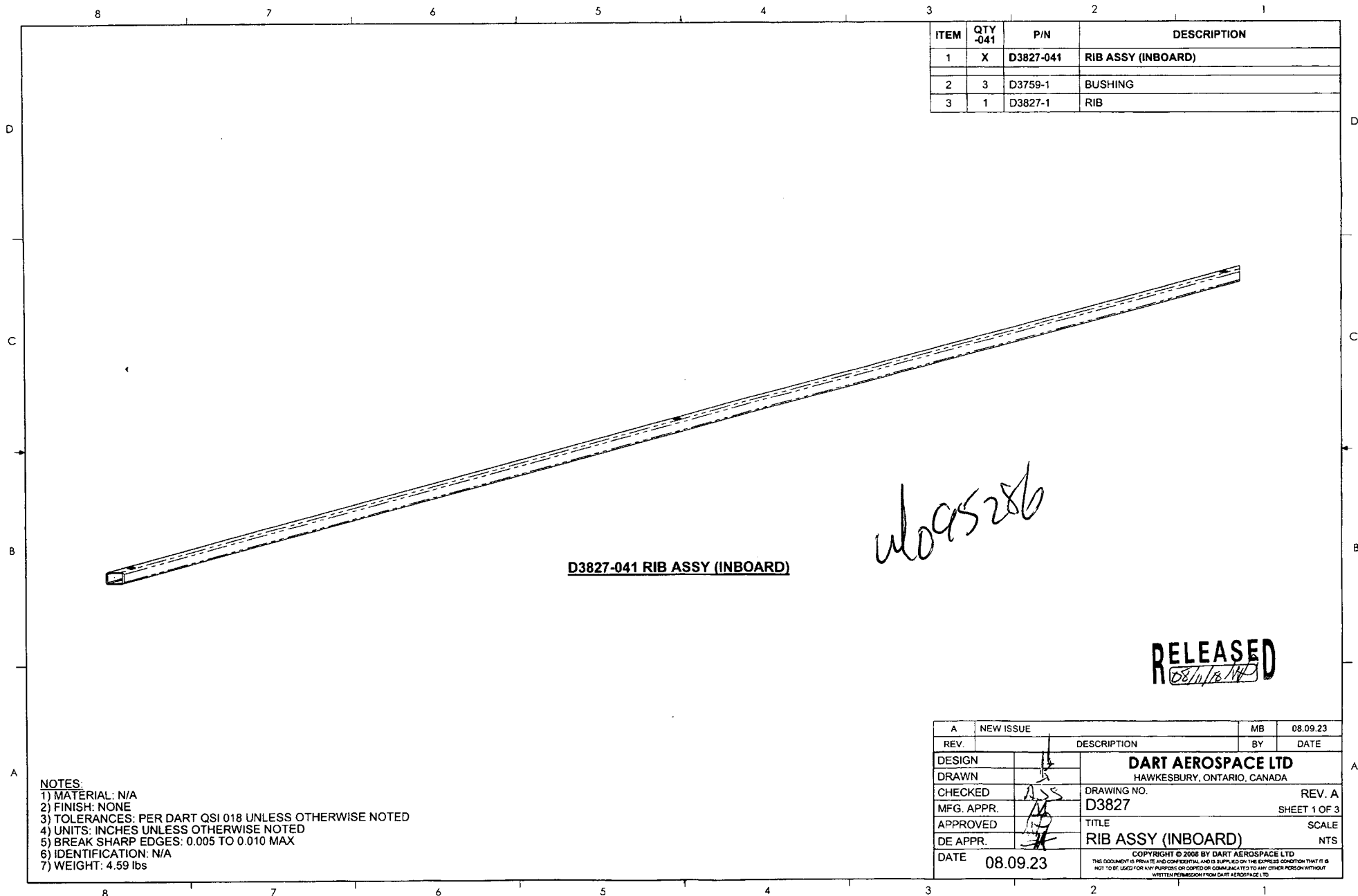
Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

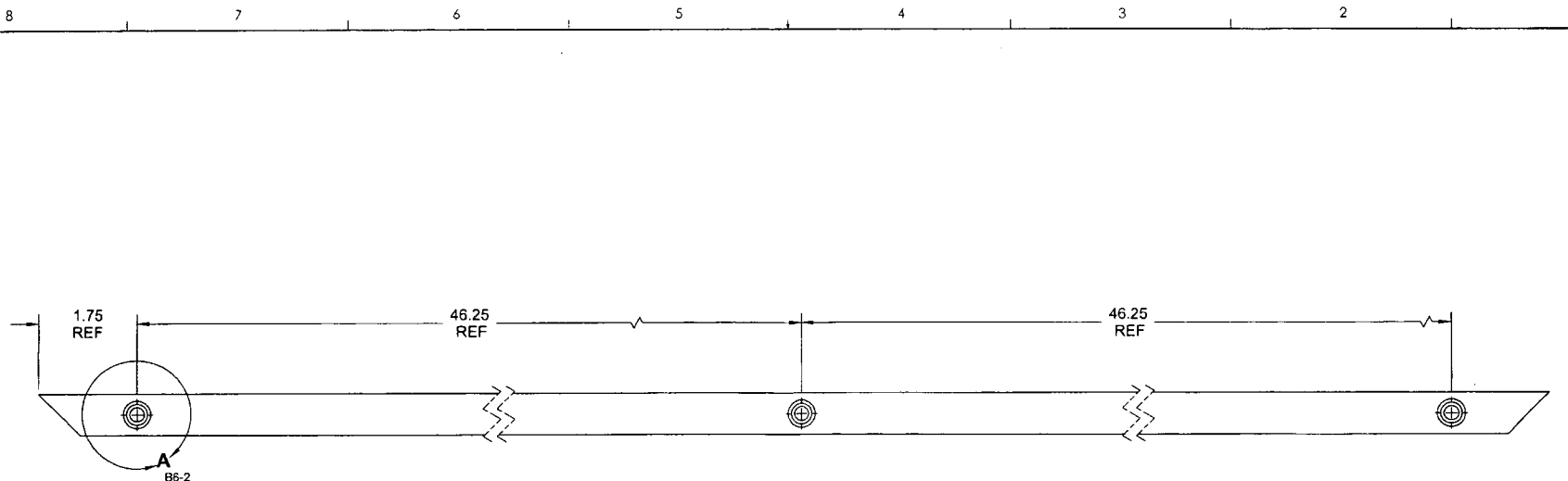
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3759-1 Bushing		Manufactured	No			100	Each	244.0000	3	6			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA004		244							
				66489		1							
				79213		1							
				83464		7							
				86550		20							
				89780		11							
				90786		204							
M304TS0.750W.065 304 SQ Tube .75x.75x.065W		Purchased	No			100	f	2,404.2164	8	16.842105			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				MAT017		1448.153597							
				122468		448.153597							
				124069		1000							
				WA006		956.0628							
				122051		41							
				123303		874.0628							
				7636		41							

CP 13-1-8  
B90786 → (6)

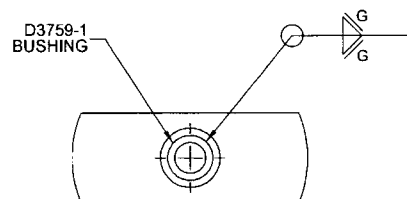
CP 13-1-8

16.84





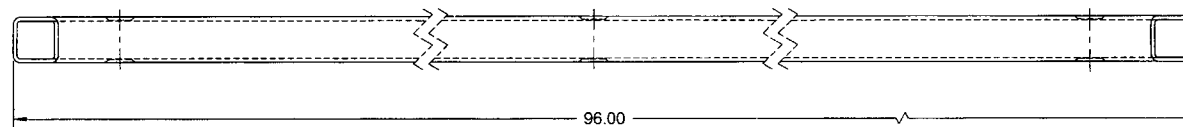
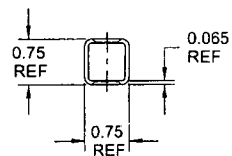
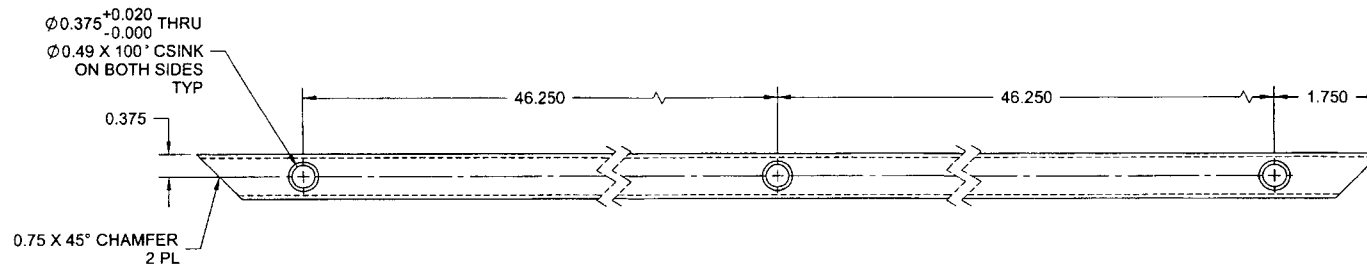
**D3827-041 RIB ASSY (INBOARD)**



**DETAIL A**  
SCALE 2X  
3 PL

**RELEASED**  
08/11/18

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ASS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>MP</i>	<b>D3827</b>	SHEET 2 OF 3
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	<b>RIB ASSY (INBOARD)</b>	NTS
DATE	<b>08.09.23</b>	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



**D3827-1 RIB**

**RELEASED**  
08/11/18/WP

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.55 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3827	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (INBOARD)	NTS
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